

Date: Tuesday, 1/23/2007 7:33:43 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 30401  
Estimate Number : 11107  
P.O. Number : N/A  
This Issue : 1/23/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 28332  
Written By :                       
Checked & Approved By :                       
Comment : Est Rev: A 05.10.18 New issue KJ/EC

Drawing Name : STEM  
Part Number : D34071  
Drawing Number : D3407 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : N/A  
Due Date : 2/15/2007

Qty: 22 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174R0750 Inventory



Comment: Qty.: 0.3843 f(s)/Unit Total: 15.3720 f(s)

Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)

Batch: M100841 Scrap 1 parts 7" Scrap 1 part 10"

M18742 x 40" 1 part scrap 7"

J.P. / MS 07/03/19 (22)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA596 Rev: AA & Dwg D3407 Rev: C

2-Deburr

J.P. / MS 07/03/19 (22)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.S. 07/03/20 (22)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

J.F. 07/03/20 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   R   Date:   17/03/21    
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:33:43 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 30401

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 07/03/20

(22)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS10

FC 07/03/21 (22)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/21

Job Completion



07.03.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Wrong

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30401
<b>Description:</b> Tow Ring		<b>Part Number:</b>	D3407-1
<b>Inspection Dwg:</b> D3407 <b>Rev:</b> C		Page 1 of 1	

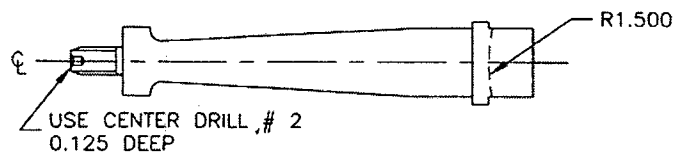
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	+/-0.010	5.270	✓			
4.250	+0.000/-0.010	4.240	✓			
3.250	+/-0.010	3.250	✓			
0.500	+/-0.010	.501	✓			
0.500	+/-0.010	.500	✓			
0.470	+/-0.010	.476	✓			
Ø0.625	+0.008/-0.001	.627	✓			
Ø0.750	+0.008/-0.001	.756	✓			
Ø0.625	+0.008/-0.001	.628	✓			
Ø0.363	+0.006/-0.001	.369	✓			
0.063 Ref	+/-0.010	0.063	✓			
R0.020	+/-0.010	R0.020	✓			
0.550	+/-0.010	.550				
0.625	+/-0.010	.628	✓			
0.250	+0.010/-0.000	.251"	✓			
0.150	+/-0.010	.150"	✓			
MOW = 0.266	+/-0.001	.266	✓			

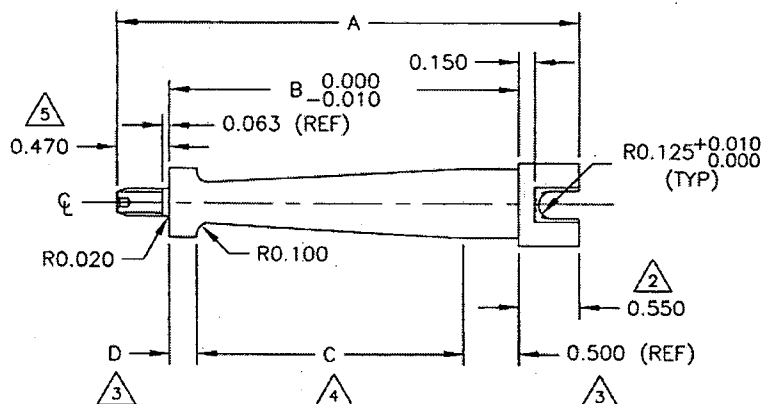
<b>Measured by:</b> S.K./J.F.	<b>Audited by:</b> En.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/20	<b>Date:</b> 07/03/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

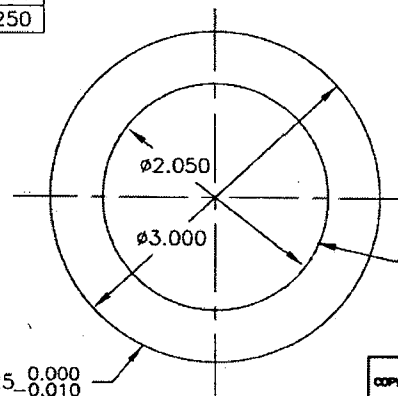
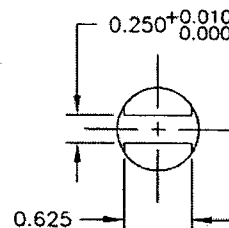
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

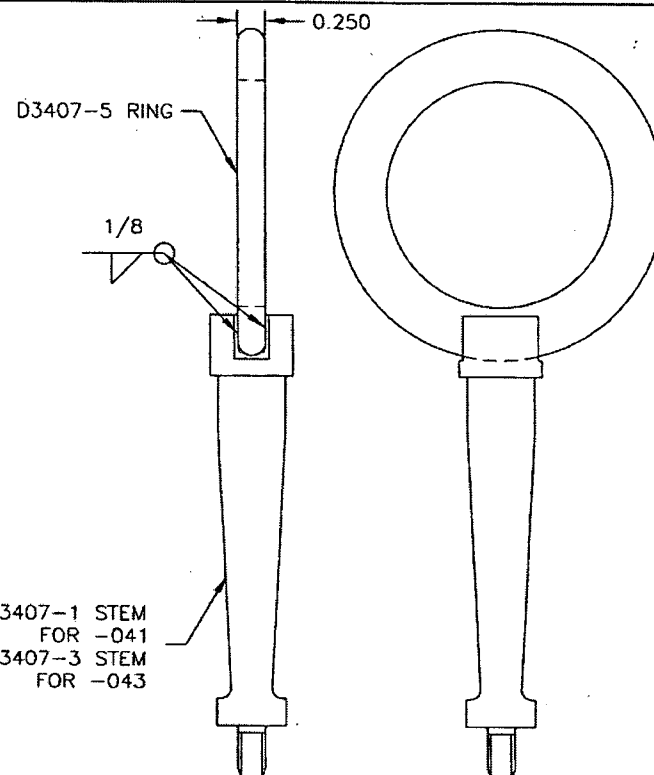
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D3407-5 RING



USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043

### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED CP
DATE	05.09.09	DRAWING NO. D3407
		TITLE TOW RING

DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

SHEET 1 OF 1

SCALE 1:1

NO. 30401  
WORK ORDER  
WITHOUT NOTICE  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY